Work Order ID <i>May-31-12 9:09:39 AM</i>	85001		*850)∩₁1 *	+ 4		_				Page
Item ID: D212-77 Revision ID:	25-1-111		Accept	*N900	040	100)*	Setup	Start		S1*
Item Name: ENGINE	MOUNT DECK FITTING		23						Stop	*N	S2*
Start Date: 5/31/12	Start Qty: 2.00	*2*		Cust Item I	D:						
Required Date: 5/31/12	Req'd Qty: 2.00	*2*		Customer:							
Reference: rework	to new rev					_		Б	C40 m4		
Approvals: Proces	s Plan:	Date:	Tooling:	Da	ite:		· .	Run	Start	*N	R1*
QC:_	-	_ Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						-				
D4231	A U/R								,		
*105 *105* Mill Conv Conventional Milling Machine	2 X D212-7	M STK: 725-1-111 B45608 MILL PER NEW REV.	0.00		$\mathcal{O}^{\prime\prime}$	ne (N S	W	ing.	Je V	
*120 *120*	QC2-Inspect parts off r	nachine FAI/FAIB	0.00			X		KOV	~	1	
QC Quality Control	Memo	- ;	0.00								
	3										-
130	QC8- Inspect parts - sec	cond check	0.00						V_) 0]1(U)
130 QC Quality Control	Мето		0.00	į					10		

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Work Order ID 85001 May-31-12 9:09:39 AM				*8500)1*						Page 2
Item ID:	D212-725-1	-111		Accept	*N900	040	100)* s	etup Star	*N	S1*
Revision ID: Item Name:	ENGINE MO	UNT DECK FITTING							Stop	*N:	S2*
Start Date: Required Date:	5/31/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D :					
Reference:	rework to ne		*7*		Customer.		_		Stan	4	
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:		K	kun Star Stoj	171	R1*
QC:			Date:	SPC (Y/N):	Da	Date:			510	*NR2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		Outsource process-Cadpla	te per QSI017 4.1.9.1	0.00							
140 Outsource3		Memo		0.00							
Outsource process -	Cad plate	Issue P/O: IIConformity	Cac sheet required	i Plate per QQ-P-416F Class I	Туре						
150		Receive & Inspect for Dar	nage & Mat'l Certs	0.00							
150 Packaging		Memo		0.00							
Packaging		Ensure certifi	cate of conformity is at	acneu							

0.00

0.00

QC3- Inspect Part Finish

Memo

160

160

Quality Control

Work Ord <i>May-31-12 9:09</i>		001		*850) 01*						Page 3
Item ID: Revision ID:	D212-725-1-	-111		Accept	*N900	040	100)* s	etup Sta	171	
Item Name:	ENGINE MO	UNT DECK FITTING							Sto	^p *N:	S2*
Start Date: Required Date:		Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Reference: Approvals:	Process Pla		Date:	Tooling:	D:	ate:		R	un Sta	\	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			310	^ν *Ν'	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		Identify as per dwg & Sto	ock Location:	0.00							
170 Packaging Packaging		Memo		0.00							
180		QC21- Final Inspection -	Work Order Release	0.00							
*1 8 0 *		Memo		0.00					- -		

Memo

Quality Control

May-31-12 9:09:39 AM

Work Order ID:

85001

Parent Item:

D212-725-1-111

Parent Item Name:

ENGINE MOUNT DECK FITTING

Start Date: 5/31/12

Required Date: 5/31/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 06-12-19 JLM

IPP Rev:B Added Cad Plating 07-07-23 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-1-111		Manufactured	No				Each	0.0000		2			

Linda Lacelle

From:

Jean-Luc Menard < jmenard@dartaero.com>

Sent:

May-30-12 1:41 PM

To:

'Linda Lacelle'

Subject:

RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Conv milling

mill as per new rev

Qc2 Oc8

I think we will have to re cad plate.

~ 4560g

JL

From: Linda Lacelle [mailto:llacelle@dartaero.com]

Sent: Wednesday, May 30, 2012 12:56 PM

To: 'Jean-Luc Menard'

Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Will you take them out of stk pls, write up what has to be done, and I'll make the w/o from that...

Thx L

From: Jean-Luc Menard [mailto:jmenard@dartaero.com]

Sent: May-30-12 12:53 PM

To: 'Linda Lacelle'; 'Roberto Fuentes'

Cc: 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'

Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Yes we will be able to re-work them.

JLM

From: Linda Lacelle [mailto:llacelle@dartaero.com]

Sent: Wednesday, May 30, 2012 6:10 AM To: 'Roberto Fuentes'; 'Jean-Luc Menard '

Cc: 'Eric Downing'; 'David Shepherd'; 'Mike Petsche'; 'David Shepherd'; 'Kim Johnston'

Subject: RE: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

Only 2 x D212-725-1-111 in stk...JL can you let me know if these can be reworked..

From: Roberto Fuentes [mailto:rfuentes@dartaero.com]

Sent: May-29-12 6:47 PM

To: Linda Lacelle

Cc: Jean-Luc Menard; Eric Downing; David Shepherd; Mike Petsche; David Shepherd; Kim Johnston

Subject: D212-725-1-109/-110/-111 Engine mounts for Eagle Single

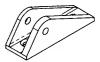
Hi Linda,

I just posted D4231-PB2 engine mount drawing for review and approve by production. If there is any W/O in progress need to be updated per this new drawing and check the stock. I just got the feedback from Eagle today.

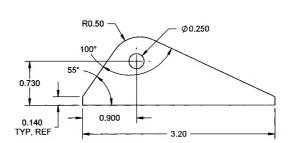
Thanks, Roberto

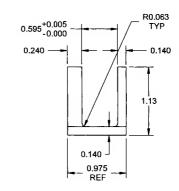
CSK Ø0.470 x 100° Ø0.313 -TO THIS DIAMETER Ø0.250 0.438 0.588 2.162





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PRELIMINARY ISSUE

₽ 12.05.29

CSK Ø0.470 x 100* WAS Ø0.446 x 45* CHAMFER (ZN D5-1, D5-2) 12.05.29 Α NEW ISSUE RF 11.02.24 DESCRIPTION REV. BY DATÉ DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. PB2 D4231 MFG. APPR SHEET 1 OF 3 TITLE APPROVED SCALE **ENGINE MOUNT** DE APPR. NTS

D212-725-1-109 SMALL ENGINE MOUNT, LH

NOTES: 1) MATERIAL: AISI 4140 STEEL BAR PER MIL-S-5626 OR AMS 6382/6349/6529 REF DART SPEC. M4140N-B OR AISI 4130 STEEL BAR PER MIL-S-6758 OR AMS 6345/6348/6370/6528 REF DART SPEC. M4130N-B HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi 2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

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7) WEIGHT: 0.30 lbs

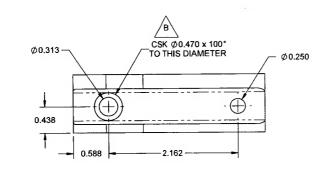
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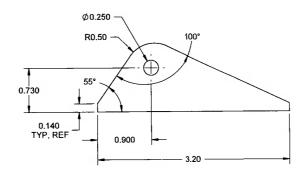
5

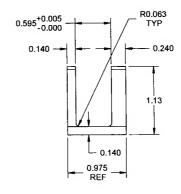
12.05.29

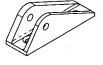
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D212-725-1-110 SMALL ENGINE MOUNT, RH

PRELIMINARY ISSUE

₽ 12.05.29

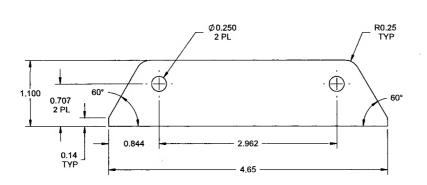
NOTES: 1) MATERIAL: AISI 4140 STEEL BAR PER MIL-S-5626 OR AMS 6382/6349/6529 REF DART SPEC. M4140N-B REF DART SPEC. M4140N-B
OR AISI 4130 STEEL BAR
PER MIL-S-6758 OR AMS 6345/6348/6370/6528
REF DART SPEC. M4130N-B
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
2) FINISH: CADMIUM PLATE PER AMS-QQ-P-416B, CLASS I, TYPE II
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.30 lbs

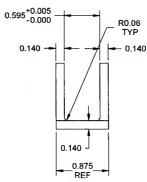
DESIGN	JL	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARI	O, CANADA	
CHECKED	AS-	DRAWING NO.	REV. PB2	
MFG. APPR.		D4231	SHEET 2 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		ENGINE MOUNT	NTS	
DATE 12.0	5.29	THIS DOCUMENT IS PRINKITE AND COMPENSATION AND IS SUPPLIED ON THE EXPRESS ODMOTTON THAT IT IS NOT TO BE USED FOR ANY AURTOIS ON COMPENSATION OF COMPENSATION OF ANY OTHER EXPRESS OF COMPENSATION OF ANY OTHER EXPRESS OF COMPENSATION OF ANY OTHER PRINCIPLANT WITHOUT		

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D212-725-1-111 LARGE ENGINE MOUNT

NOTES:
1) MATERIAL: AISI 4140 STEEL BAR
PER MIL-S-5626 OR AMS 6382/6349/6529
REF DART SPEC. M4140N-B
OR AISI 4130 STEEL BAR
PER MIL-S-6758 OR AMS 6345/6348/6370/6528
REF DART SPEC. M4130N-B
HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
2) FINISH: CADMIUM PLATE PER AMS-02.P-416B, CLASS I, TYPE II
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.47 lbs

PRELIMINARY ISSUE

₹ 12.05.29

DESIGN	JL	DART AEROSPA	CE LTD
DRAWN	RF	HAWKESBURY, ONTARIO	O, CANADA
CHECKED	9	DRAWING NO.	REV. PB2
MFG. APPR.		D4231	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ENGINE MOUNT	NTS
DATE 12.0	5.29	COPYRIGHT © 2011 BY DART AI THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNICA WRITTEN PERMADRIN FROM DART ARE	ON THE EXPRESS CONDITION THAT IT IS TED TO ANY OTHER PERSON WITHOUT

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